

# Work Order ID 53432

November 4, 2009 10:18:07 AM



Page 1

Item ID: D2432

Accept



Setup/Start



Revision ID: F3

Stop



Item Name: 206 (24") Bearpaw

Start Date: 11/09/09 Start Qty: 16.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								

120  
  
 Waterjet  
 FLOW CNC Waterjet

FLOW WATER JET  
 Memo  
 Cut Blank as per D2432 File

0.00

0.00

*18 9-11-17*

130  
  
 HAAS 1  
 HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1  
 Memo  
 1-Inspect material for defects or damage prior to machining  
 2-Machine as per Folio and Dwg D2432 Identify as D2432F  
 3-Deburr

0.00

0.00

*M.A 09/11/23*

*DIT 09/11/24*

*18*

140  
  
 QC  
 Quality Control

QC2- Inspect parts off machine FAI/FAIB  
 Memo

0.00

0.00

*M.A 09/11/23*

*DIT 09/11/24*

*18*

*PTO last page*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: \_\_\_\_\_ Fault Category: machined parts NCR: (Yes) No DQA: [Signature] Date: 09.11.30  
 Resolution: accepted Disposition: use as is QA: N/C Closed: [Signature] Date: 09.11.30

NCR: 53432		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/11/24	130	3 Parts → chamfer are uneven because the material had flex back to its original shape after the outside profil was cut. (up to .090" over tol.) <del>R.C.</del> R.C. process.	<u>[Signature]</u> 09.11.25 per OS/042	Acceptable per Eng.	<u>[Signature]</u> 09/11/24	<u>[Signature]</u> 09.11.25	<u>[Signature]</u> 09.11.25 per OS/042	<u>[Signature]</u> 09.11.25

NOTE: Date & initial all entries

# Work Order ID 53432

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Item ID: D2432

Accept



Setup Start



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Stop



Item Name: 206 (24") Bearpaw

Start Date: 11/09/09 Start Qty: 16.00



Cust Item ID:

Required Date: 11/13/09 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8: Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
151	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

*09.11.25*

*(18)*

*09/11/26 (18)*

*PPA  
S2233 164  
2 stock*

*09/11/27  
PL 09-11-26  
(18)*

# Picklist Print

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Page 1

Work Order ID: 53432

Parent Item: D2432RevF3

Parent Item Name: 206 (24") Bearpaw

Comments:

Start Date: 11/09/09

Required Date: 11/13/09

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	219.8629	59.2000			



UHMW 1" Black



89-11-17

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT

177.7752

112186

126.5752

112514

51.2

Main Warehouse

ST

42.0877

111354

42.0877

113166

89-11-17  
113166

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 53432
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.060x45°	✓		
B	5.500	+/-0.030	5.503	✓		
C	0.200	+/-0.030	0.199	✓		
D	0.25 x 45°	+/-0.030	0.250x45°	✓		
E	R0.250	+/-0.030	R0.250	✓		
F	0.250	+/-0.010	0.256	✓		
G	0.625	+/-0.030	0.630	✓		
H	0.375	+/-0.010	0.381	✓		
I	0.950	+0.030/0.010	0.958	✓		
J	19.000	+/-0.030	19.000	✓		
K	3.14	+/-0.030	3.150	✓		
L	3.28	+/-0.030	3.295	✓		
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		
N	Ø0.93	+/-0.030	Ø0.925	✓		
O	0.30	+0.030/-0.000	0.310	✓		
P	23.750	+/-0.030	23.750	✓		
Q	7.375	+/-0.030	7.377	✓		
R	4.250	+/-0.010	4.250	✓		
S	2.000	+/-0.030	1.997	✓		
T	9.000	+/-0.010	9.000	✓		
U	9.000	+/-0.010	9.000	✓		
V	0.375	+/-0.010	0.380	✓		

<b>Measured by:</b> L.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/11/23	<b>Date:</b> 09-11-25	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF [Signature]

F1	99-03-03	ADD DEC 9143	
F2	01-03-28	0043 WAS 0076	RF
F3	02-01-23	CLARIFY CORE DMS	RF

48.06 17 KG

# DART



DESIGN KE	DRAWING BY KE	DARI AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
CHECKED MM	APPROVED AS		SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:6	

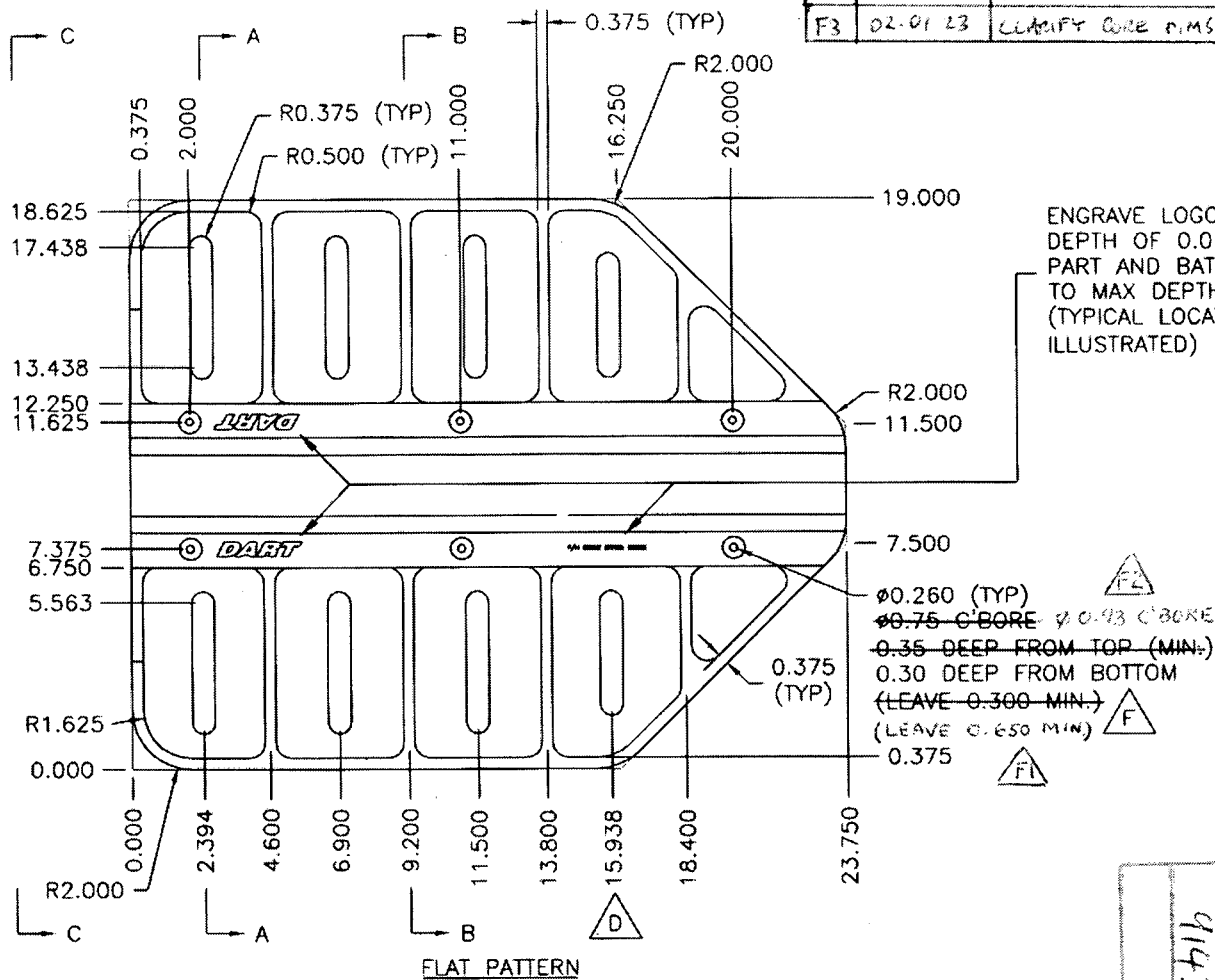
DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. F

**SHEET 1 OF 2**

SCALE



ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)

# EFFECTIVE DEOS

9143

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

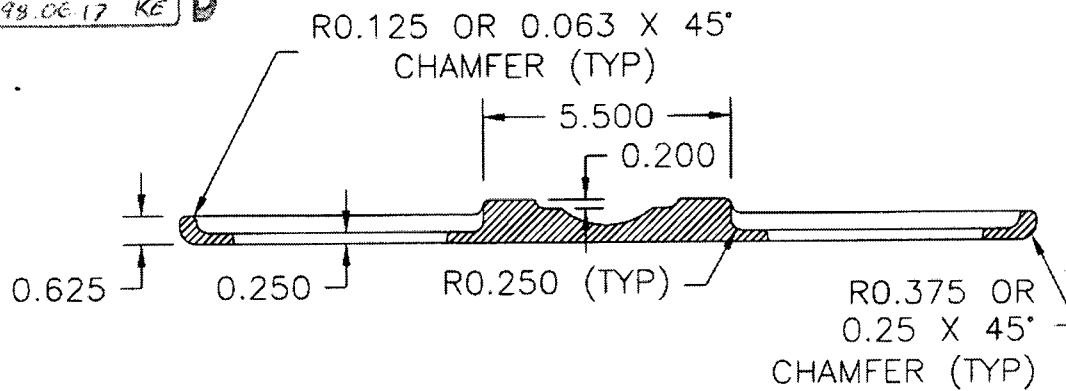
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

53432

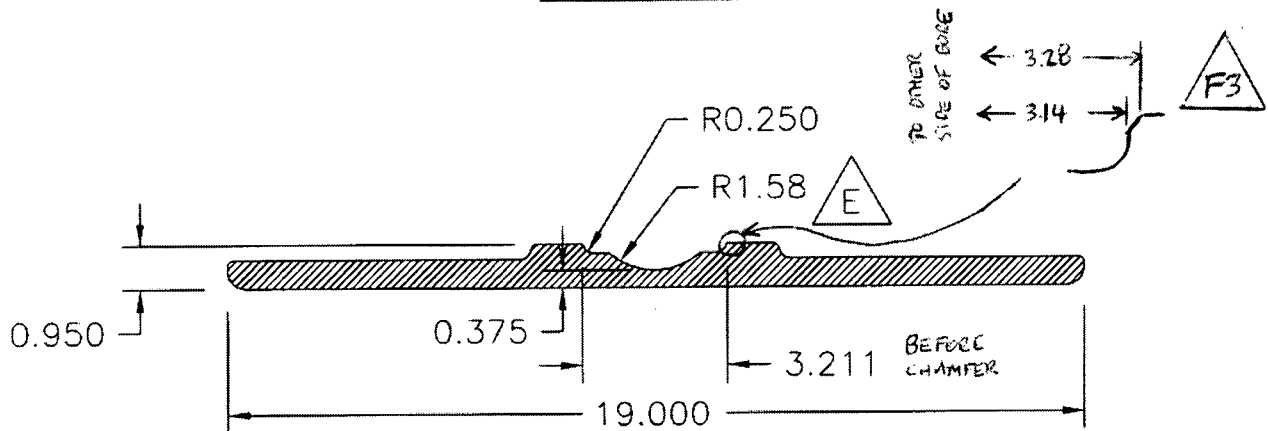


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

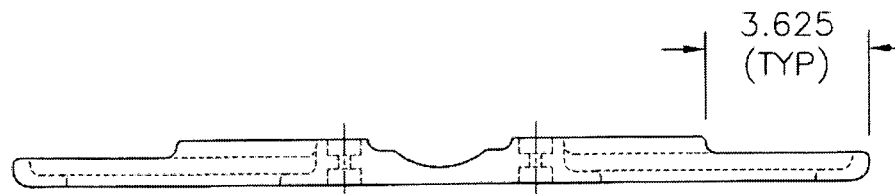
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C